



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D5491-042
Job Sheet 188264



Part No: D5491-042

Job Qty: 1 pcs

DAS
21
9-89

Part Name: Step Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/6/19

Job Tracking No:

Due Date: 1/18/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: D5491 REV.B IPP REV:A 18.04.04 NEW ISSUE DD VERF:JFS IPP REV:B 18/08/03 AS PER DWG REV.B
JFS VERF BY:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	1 pcs	1/18/19		0.00	8.33	Small Fab - 1		DAS 58 9-89 MAY 09 2019
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	1 pcs	1/18/19		0.00	0.00	QC 5 - 10		DAS 19 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
130	Spray Paint - 2 - B4B	1 pcs	1/18/19		0.00	0.50	Spray Paint - 1 - B4B		AB 19-5-10
							Spray Paint - 2 - B4B		
							Spray Paint - 3 - B4B		
							Spray Paint - 4 - B4B		
140	QC 14	1 pcs	1/18/19		0.00	0.00	QC 14 - 15		



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Hawkesbury, ON K6A 1K7
CANADA
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Container No: S180017



Part: D5491 - 042

Job No: 188264

Serial No/Batch: S180017

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

Date: 05/10/19

					QC 14 - 2	
					QC 14 - 34	
					QC 14 - 38	
					QC 14 - 41	
					QC 14 - 51	DAS
					QC 14 - 58	19
					QC 14 - 59	9-89
					QC 14 - 9	
					QC 14 - 68	
150 Handfinish - 3-1- WingWalk- B4B	1 pcs	1/18/19	0.00 0.50	Handfinish - 3 - 1 - B4B		RD 17-5-11
				Handfinish - 3 - 2 - B4B		
				Handfinish - 3 - 3 - B4B		
				Handfinish - 3 - 4 - B4B		
				Handfinish - 3 - 5 - B4B		
160 QC 3	1 pcs	1/18/19	0.00 0.00	QC 3 - 10		
				QC 3 - 13		
				QC 3 - 15		
				QC 3 - 17		
				QC 3 - 18		
				QC 3 - 2		
				QC 3 - 26		
				QC 3 - 28		
				QC 3 - 3		
				QC 3 - 30		
				QC 3 - 34		
				QC 3 - 36		
				QC 3 - 38		
				QC 3 - 41		
				QC 3 - 51		
				QC 3 - 58		
				QC 3 - 59		
				QC 3 - 6		DAS
				QC 3 - 68		MAY 13 2019 68
				QC 3 - 9		9-89
170 Packaging 3-1 - Stock - B4B	1 pcs	1/18/19	0.00 0.00	Packaging 3 - 1 - B4B		DAS
				Packaging 3 - 2 - B4B		46 MAY 13 2019
				Packaging 3 - 3 - B4B		9-89
				Packaging 3 - 4 - B4B		
				Packaging 3 - 5 - B4B		
				Packaging 3 - 6 - B4B		
				Packaging 3 - 7 - B4B		
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		

				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	D46
180	QC 21 - SA	1	1/18/19	0.00 0.00	QC 21 - SA - 21
		pcs			QC 21 - SA - 70
Part Op 110 - (Small Fab) 1- ASSEMBLE FIXTURE DT10384 WITH BLOC "A", "B" AND "C" TO MANUFACTURE D5491-041. 2- Descriptions: ASSEMBLE D5273-043 FITTINGS TO D5491-1 STEP WITH PROSEAL AS PER DWG A/R PROSEAL: <u>5176610</u> 3- INSERT ALL PARTS TOGETHER IN FIXTURE DT10384 AND TRANSFER DRILL HOLES USING DT10186 FOR D5499-1 AND DT 10185 FOR D5499-1 AS PER DWG AND NOTES 8,9. 4- DISASSEMBLE AND DEBURR. 5- a) USE DT10170 DRILL JIG TO DRILL NUT PLATE HOLES IN D5627-1 TUBE AS PER DWG. b) DEBURR c) TOUCH UP HOLES WITH ALODINE ONLY d) INSTALL NUTPLATES IN TUBES 6- TOUCH UP HOLES WITH ALODINE ONLY ON D5627 AND D5273-041 FITTINGS. 7- USE DT10384 TO RE-ASSEMBLE REST OF THE PARTS TOGETHER USING PROSEAL AS PER DWG A/R PROSEAL: <u>5176610</u> CURE TIME 24h: _____ 120 - (QC5- Inspect part completeness to step on W/O) 130 - (Spray Paint / NDT Room) Prime and paint as per dwg. ***MASK SLOTS AS PER NOTE 10*** Primer <u>5163577</u> Paint <u>5173197</u> 140 - (QC14- Inspect Spray Paint) 150 - (Wing Walk as per dwg QSI005 4.4 Batch <u>5163439</u> 1- MASK SCREWS AS PER DWG AND APPLY WING WALK AS PER DWG. 2- INSTALL PLACARD AS PER DWG. (NOTE11) 160 - (QC3- Inspect Part Finish) 170 - (Identify as per dwg & Stock Location: _____) 180 - (QC21- Final Inspection - Work Order Release)					

009703

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
CR3212-4-05	Cherry Rivet	30, 6 Ea (6 ea)	110-Small Fab - 1	5105480
CR3242-4-4	Rivet	40, 8 Ea (8 ea)	110-Small Fab - 1	F104322
D5273-043	End Fitting Assembly	5, 1 pcs (1 ea)	110-Small Fab - 1	F140321
D5291-041	Radius Block Assembly	15, 3 pcs (3 ea)	110-Small Fab - 1	F144620
D5491-1	Step Extrusion	5, 1 pcs (1 ea)	110-Small Fab - 1	S142684
D5499-2	Aft Bracket Mount	5, 1 pcs (1 ea)	110-Small Fab - 1	S179469
D5625-1	Receptacle	20, 4 pcs (4 ea)	110-Small Fab - 1	S112955
D5627-1	Tube	5, 1 pcs (1 ea)	110-Small Fab - 1	S174319
D5629-041	End Cap Assembly	5, 1 pcs (1 ea)	110-Small Fab - 1	S118458
MS21042L3	Nut	10, 2 Ea (2 ea)	110-Small Fab - 1	S157462
MS24694-S50	Screw	40, 8 Ea (8 ea)	110-Small Fab - 1	S093692
MS24694-S98	Screw	15, 3 Ea (3 ea)	110-Small Fab - 1	S136197
MS27039-1-10	Screw	5, 1 Ea (1 ea)	110-Small Fab - 1	S148665
MS27039-1-30	Screw	10, 2 Ea (2 ea)	110-Small Fab - 1	S062615
NAS1149D0332J	Washer	10, 2 Ea (2 ea)	110-Small Fab - 1	S164289
NAS1149D0363J	Washer	20, 4 Ea (4 ea)	110-Small Fab - 1	S162884
D2137	Decal(No Step)	5, 1 pcs (1 ea)	150-Handfinish - 3-1- WingWalk-B4B	S160496

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	CR3212-4-05	6	188	0
	CR3242-4-4	8	343	0
	D5273-043	1	23	0
	D5291-041	3	162	0
	D5491-1	1	7	0
	D5499-2	1	0	0
	D5625-1	4	100	0
	D5627-1	1	6	0
	D5629-041	1	0	0
	MS21042L3	2	1,949	0
	MS24694-S50	8	246	0
	MS24694-S98	3	128	0
	MS27039-1-10	1	157	0
	MS27039-1-30	2	32	0
	NAS1149D0332J	2	2,738	0
	NAS1149D0363J	4	937	0
150-Handfinish - 3-1- WingWalk-B4B	D2137	1	27	0

Part Specifications

Specifications could not be found.



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Job Sheet 188264



Part No: D5491-042

Job Qty: 1 ea

Part Name: Step Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/6/19

Job Tracking No:

Due Date: 1/18/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: D5491 REV.B IPP REV:A 18.04.04 NEW ISSUE DD VERF:JFS IPP REV:B 18/08/03 AS PER DWG REV.B
JFS VERF BY:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	1/18/19	1/18/19	0.00	0.00	Start Up Small Fab-4		
110	Small Fab	1 pcs	1/18/19	1/18/19	0.00	8.33	Small Fab-8		
120	QC	1 pcs	1/18/19	1/18/19	0.00	0.00	QC5		
130	SprayPaint	1 pcs	1/18/19	1/18/19	0.00	0.50	Spray Paint		
140	QC	1 pcs	1/18/19	1/18/19	0.00	0.00	QC14		
150	HandFinish	1 pcs	1/18/19	1/18/19	0.00	0.50	HandFinish3		
160	QC	1 pcs	1/18/19	1/18/19	0.00	0.00	QC3		
170	Packaging	1 pcs	1/18/19	1/18/19	0.00	0.00	Packaging3-2		
180	QC21-SA	1 Ea	1/18/19	1/18/19	0.00	0.00	QC21		

Part Op 110 - 1- ASSEMBLE FIXTURE DT10384 WITH BLOC "A", "B" AND "C" TO MANUFACTURE D5491-041. 2- ASSEMBLE
Descriptions: D5273-043 FITTINGS TO D5491-1 STEP WITH PROSEAL AS PER DWG A/R PROSEAL: _____ 3- INSERT
ALL PARTS TOGETHER IN FIXTURE DT10384 AND TRANSFER DRILL HOLES USING DT10186 FOR D5499-1 AND
DT 10185 FOR D5499-1 AS PER DWG AND NOTES 8,9. 4- DISASSEMBLE AND DEBURR. 5- a) USE DT10170 DRILL
JIG TO DRILL NUT PLATE HOLES IN D5627-1 TUBE AS PER DWG. b) DEBURR c) TOUCH UP HOLES WITH
ALODINE ONLY d) INSTALL NUTPLATES IN TUBES 6- TOUCH UP HOLES WITH ALODINE ONLY ON D5627 AND
D5273-041 FITTINGS. 7- USE DT10384 TO RE-ASSEMBLE REST OF THE PARTS TOGETHER USING PROSEAL AS
PER DWG A/R PROSEAL: _____ CURE TIME 24h: _____
130 - Prime and paint as per dwg. ***MASK SLOTS AS PER NOTE 10***
150 - 1- MASK SCREWS AS PER DWG AND APPLY WING WALK AS PER DWG. 2- INSTALL PLACARD AS PER
DWG. (NOTE11)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
CR3212-4-05	Cherry Rivet	6 Ea (6 ea)	90-Start up Operation	
CR3242-4-4	Rivet	8 Ea (8 ea)	90-Start up Operation	
D5273-043	End Fitting Assembly	1 Ea (1 ea)	90-Start up Operation	
D5291-041	Radius Block Assembly	3 Ea (3 ea)	90-Start up Operation	
D5491-1	Step Extrusion	1 pcs (1 ea)	90-Start up Operation	
D5499-2	Aft Bracket Mount	1 Ea (1 ea)	90-Start up Operation	
D5625-1	Receptacle	4 pcs (4 ea)	90-Start up Operation	
D5627-1	Tube	1 Ea (1 ea)	90-Start up Operation	
D5629-041	End Cap Assembly	1 pcs (1 ea)	90-Start up Operation	
MS21042L3	Nut	2 Ea (2 ea)	90-Start up Operation	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

MS24694-S50	Screw	8 Ea (8 ea)	90-Start up Operation	
MS24694-S98	Screw	3 Ea (3 ea)	90-Start up Operation	
MS27039-1-10	Screw	1 Ea (1 ea)	90-Start up Operation	
MS27039-1-30	Screw	2 Ea (2 ea)	90-Start up Operation	
NAS1149D0332J	Washer	2 Ea (2 ea)	90-Start up Operation	
NAS1149D0363J	Washer	4 Ea (4 ea)	90-Start up Operation	
D2137	Decal(No Step)	1 pcs (1 ea)	150-HandFinish	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	CR3212-4-05	6	188	0
	CR3242-4-4	8	343	0
	D5273-043	1	23	0
	D5291-041	3	162	0
	D5491-1	1	0	0
	D5499-2	1	0	0
	D5625-1	4	100	0
	D5627-1	1	6	0
	D5629-041	1	0	0
	MS21042L3	2	2,545	0
	MS24694-S50	8	246	0
	MS24694-S98	3	144	0
	MS27039-1-10	1	167	0
	MS27039-1-30	2	32	0
	NAS1149D0332J	2	2,130	0
	NAS1149D0363J	4	1,875	0
150-HandFinish	D2137	1	29	0

Part Specifications

Specifications could not be found.

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up			
Other/Details:					